



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7811

Job Sheet 205064



Part No: 647.7811

Job Qty: 8 pcs

Part Name: Bracket B



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/27/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 3/30/20

Description:

Type: Stock

Note: DWG REV A IPP Rev A: RQ 15.08.06 Verified by: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Bandsaw - 1	8 pcs	3/30/20	3/30/20	0.00	0.37	Bandsaw - 1	ALA 20/03/19
110	HAAS 4 Axis - B4B	8 pcs	3/30/20	3/30/20	0.72	3.80	HAAS - 1 - B4B	
							HAAS - 2 - B4B NV5000-2-B4B	ALA 20/03/19
							HAAS - 3 - B4B	
							HAAS - 4 - B4B	
120	QC 2	8 pcs	3/30/20	3/30/20	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	ALA DAS 86 20/03/19
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S265050



Part: 647.7811

Job No: 205064

Serial No/Batch: S265050

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/19/20

130	QC 8	8 pcs	3/30/20	0.00 0.00	QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	11 20-3-26
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
140	Outsource - 4 - Anodize	8 pcs	3/30/20		ATG001-VC	5 11 2020-03-27
150	Packaging 2-1 - Receive - B4B	8 pcs	3/30/20	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	11 MAY 07 2020
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	

					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					Packaging 2 - 37 - B4B	
155 QC 6	8 pcs	3/30/20	0.00 0.00		QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
180 Packaging 3-1 - Stock - B4B	8 pcs	3/30/20	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
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					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
190 QC 21 - SA	8 pcs	3/30/20	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

DAS
40
9-89

MAY 20 2020

DAS
21
9-89

MAY 22 2020

Part Op 100 - (Bandsaw) Cut Blank at 10.313"

Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FB408

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - Issue P/O to ATG : 46189 Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A

150 - (Receive & Inspect for Damage & Mat'l Certs)

155 - (QC6- All purchased or subcontracted products)

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S6.000X0.250	7075-T6S Sheet 6" Thick Plate X 0.25" Wide	6.8720 ft (.859 ea)	100-Bandsaw - 1	5255558

8x

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6S6.000X0.250	7	1	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket B	0.090inches ± 0.005	0.095 0.085	.088	
2	Bracket B	45.000inches ± 0.500	45.500 44.500	45°	
3	Bracket B	0.255inches ± 0.005	0.260 0.250	.250	
4	Bracket B	9.810inches ± 0.010	9.820 9.800	9.811	
5	Bracket B	0.260inches ± 0.100	0.360 0.160	.260	Radius
6	Bracket B	29.900Degrees ± 0.500	30.400 29.400	29.80°	Angle
7	Bracket B	3.671inches ± 0.005	3.676 3.666	3.673	
8	Bracket B	16.900Degrees ± 0.500	17.400 16.400	16.80°	Angle
9	Bracket B	9.463inches ± 0.005	9.468 9.458	9.463	
10	Bracket B	100.000Degrees ± 0.500	100.500 99.500	100°	Angle
11	Bracket B	18.700Degrees ± 0.500	19.200 18.200	18.65°	Angle
12	Bracket B	9.092inches ± 0.002	9.094 9.090	9.093	
13	Bracket B	3.332inches ± 0.002	3.334 3.330	3.331	
14	Bracket B	7.300inches ± 0.002	7.302 7.298	7.3005	
15	Bracket B	0.397inches ± 0.002	0.399 0.395	.398	
16	Bracket B	2.575inches ± 0.002	2.577 2.573	2.5755	
17	Bracket B	2.475inches ± 0.002	2.477 2.473	2.4755	
18	Bracket B	0.500inches ± 0.002	0.502 0.498	.5005	
19	Bracket B	0.400inches ± 0.002	0.402 0.398	.4005	

Plex 12/27/19 12:45 PM Dart.lajeunesse.marie

Entered:

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only



Job: _____		DISPOSITION		DEPARTMENT/PROCESS		Engineering	
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QSI042)	
Description Work Order Deviation		Disposition					
Completed By		Lead hand / Supervisor					
QC / QA Coordinator							
Root Cause		FAULT CATEGORY					
Operator ☐		Pressure/Forced ☐		Contamination ☐		Positioned Wrong ☐	
Manufacturing Process ☐		Bending ☐		Misaligned/off center ☐		Outside Tolerance ☐	
Equip/Tooling ☐		Crushing ☐		BOM/Route ☐		Drawing ☐	
Handling/Preservation ☐		Cracks ☐		Broken/Damage/Defect ☐		Finish ☐	
Material ☐		Crimp/Kink/Ripple/Wave/Twist ☐		Incomplete/Unclear Instructions ☐		Part Lost/Missing ☐	
Product Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Misread ☐	
Process Improvement ☐		Mislabeled ☐		Fit/Function ☐			
Human Factors ☐		Other/Details: _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB046189**



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalonde, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046189
PO Date: 3/27/20
Due Date: 4/13/20
Purchase Order Revision:
Revision Date:
Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com
Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	197648	647.1912	647.1900 Rev N/C	Bracket LH : Various STC's (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O: Black Anodize as per Dwg 646.3800	Firmed X10	-	4/13/20	10 pcs	0 pcs	10 pcs	\$10.48/pcs	\$104.80
									APR 15 2020			
2	207950	RBEL135M-2905-101-09	RBEL135M-2905-101 Rev 9	Drive Pulley Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1) -Issue PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed X4	-	4/13/20	4 pcs	0 pcs	4 pcs	\$6.98/pcs	\$27.92
									APR 15 2020			
3	208336	C10-21-2	C10-21-2 Rev 2	Spring Cover -Issue P/O -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed X2	-	4/13/20	20 pcs	0 pcs	20 pcs	\$6.98/pcs	\$139.60
									APR 15 2020			

Plex 3/31/20 12:58 PM Dart.Guerin.Kimberley



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PURCHASE ORDER

POHB046189



Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	205064	647.7811	647.7800 Rev A	Bracket B : Various STC's Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A	Firmed X8	-	4/13/20	8 pcs MAY 07 2020	0 pcs	8 pcs	\$16.28/pcs	\$130.24
5	205063	647.7810	647.7800 Rev A	Bracket A : Various STC's Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A	Firmed X8	-	4/13/20	8 pcs MAY 07 2020	0 pcs	8 pcs	\$16.28/pcs	\$130.24
6	205053	647.1611	647.1600 Rev A	Wiper Deflector, Aft : Various STC's (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG :	Firmed X2	-	4/13/20	20 pcs APR 15 2020	0 pcs	20 pcs	\$12.48/pcs	\$249.60
Grand Total:												\$782.40

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/31/20 12:58 PM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 920096

Date: 06-May-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
8 ea	Part: 647.7811 BRACKET B Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Batch/Lot#: 5265778 Job: 27243 PO: POHB046189	Rev: A	DAS 40 9-89
8 ea	Part: 647.7810 Bracket A Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Batch/Lot#: 5265778 Job: 27244 PO: POHB046189	Rev: A	Expiry Date: 08/21 Line: 5
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>MAY 06 2020</u> Certified Signature: <u>/</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Made in Canada.			

RECEIVED
MAY 06 2020
DART AEROSPACE LTD.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 920096

Date: 06-May-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.		
Made in Canada.			